

Date: Wednesday, 01/10/2008 11:23:18 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	REPLACEMENT WINDOW KIT	
Job Number :	42372A	Part Number :	D350567113	
Estimate Number :	12349	Drawing Number :	N/A	
P.O. Number :		Project Number :	N/A	
This Issue :	01/10/2008	Drawing Revision :	N/A	
Prsht Rev. :	NC	Material :		
First Issue :	1/1	Due Date :	08/10/2008	Qty: 1 Um: Each
Previous Run :	42371A	Type :	SMALL/MED FAB	
Written By :				
Checked & Approved By :	MF 08-10-01			
Comment :	Est Rev:A 04-08-24 New Issue JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD350-567-113 CHG002

N/A

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

ENSURE DT 8439 TEMPLATE IS INCLUDED

3.0	D2463	Seal
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Comment: Qty.: 7.5243 f(s)/Unit Total : 7.5243 f(s)

1/2" Seal 86.6" Long

Batch: 43841

87" long

50

4.0	D3290041	Replacement Window Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Replacement Window Assy

Batch: B43863

50

5.0	21212	Receptacles
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Receptacles

Batch: M109528

9/4/08

10

50

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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6.0	26006	Camlock Stud
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Camlock Stud
Batch: M110836

7.0	2600LW	Camloc Retaining Washer
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Camloc Retaining Washer
Batch: M110178

8.0	AN526C832R9	Screw
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Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)
Screw
Batch: M110372

9.0	AN960JD8	Washer
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Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)
Washer
Batch: M110388

10.0	MS20426AD3-5	RIVET
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)
RIVET
Batch: M4179

11.0	MS21042L08	Nut
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Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)
Nut
Batch: M110002

12.0	FG778150550ROL	7781 9oz Glass 50"x125yd
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Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)
2sq yd of 7781 9oz Glass 50"x125yd
Batch: M111166

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-567-113 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 09/04/09

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>42372A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09.07</u>	<u>10.0</u>	<u>Incorrect Rivet length</u> <u>called up on w/o. 3-4</u> <u>should be MS20426A3-5</u> <u>R.C.T</u>	<u>[Signature]</u>	<u>correct estimates to</u> <u>proper 3-5 rivet size.</u>			<u>[Signature]</u>	<u>[Signature]</u>

NOTE: Date & initial all entries

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Job Number: 42372A

Part Number: D350567113

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 09/04/07

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-567-113

Location:

PPP Rev:

PP 42372 9/4/07

(P)

SO

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/08

Job Completion



MF
09-04-07

5.0 PARTS LIST

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	①	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			①	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		1			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1			D2463-0860	NEOPRENE SEAL
	9	12			2600-6	1/4 TURN FASTENER
	9	12			2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21			AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ. YD	2 SQ. YD	2 SQ. YD			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
				1 ✓	D2463-0450	NEOPRENE SEAL
				1 ✓	D3210-1	DOUBLER
				1 ✓	D3211-1	BRACKET
				1 ✓	D3212-1	FLOOR WINDOW
				1 ✓	D3213-041	DOOR ASSEMBLY
			1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
			1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
		9	8 ✓		AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
		9	8 ✓		AN960JD6	WASHER
		9	8 ✓		MS21042L06	NUT (OR MS21042-06)
		2	40 ✓		MS20470AD4-5	RIVET
		115	90 ✓		MS20470AD4-6	RIVET
		15	20 ✓		MS20470AD4-7	RIVET

REFERENCE ONLY

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Revision: D

Date: 08.07.08

42372A